

Date: Wednesday, 01/04/2009 9:20:27 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 46764			Part Number	: D2804042		
Estimate Number	: 10334			Drawing Number	: D2804 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/04/2009 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 08/04/2009 Qty: 4 Um: Each		
Previous Run	: 46640			Comment	: Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM		
Written By	:			Est Rev:G As per Rev C 06-11-08 JLM			
Checked & Approved By	: 2009.04.q						
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D28042	Bracket		
		 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) STA 155 Bracket Pick: Qty Part Number Description Batch 1 D2804-2 Bracket B4476 (1) 346315 (3) 0509/04/01		
2.0	D28052	Stop		
		 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Stop Pick: Qty Part Number Description Batch 1 D2805-2 Stop B46314 0509/04/01		
3.0	D2809	Bushing		
		 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing B16438 (3) 340929 (1) 0509/04/01		
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		 <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1-Press D2805-2 into arm as per Dwg D2804 2-Press Fit D2809 as per Dwg D2804 0509/04/01 (4)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC5 INSPECT WORK TO CURRENT STEP



*S. orlolev 44*

Comment: INSPECT WORK TO CURRENT STEP

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 *1110939*

START TIME: *13:30*

OVEN TEMPERATURE: *320°*

FINISH TIME: *14:00*

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-04-01 44*

8.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	<i>1109147</i>

9.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	<i>1110562</i>

*1109147*

10.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	<i>1109929</i>

*1109929*

A/R LPS-3

Corrosion Spray

Washer

*1109929*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: BRACKET ASSEMBLY

Job Number: 46764

Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

09/04/02 (4)

12.0 QC5 INSPECT WORK TO CURRENT STEP



09/04/02 (X)

Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1 PACKAGING RESOURCE #1



(4)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 150

9412

50

14.0 QC21 FINAL INSPECTION/W/O RELEASE



09/04/03 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

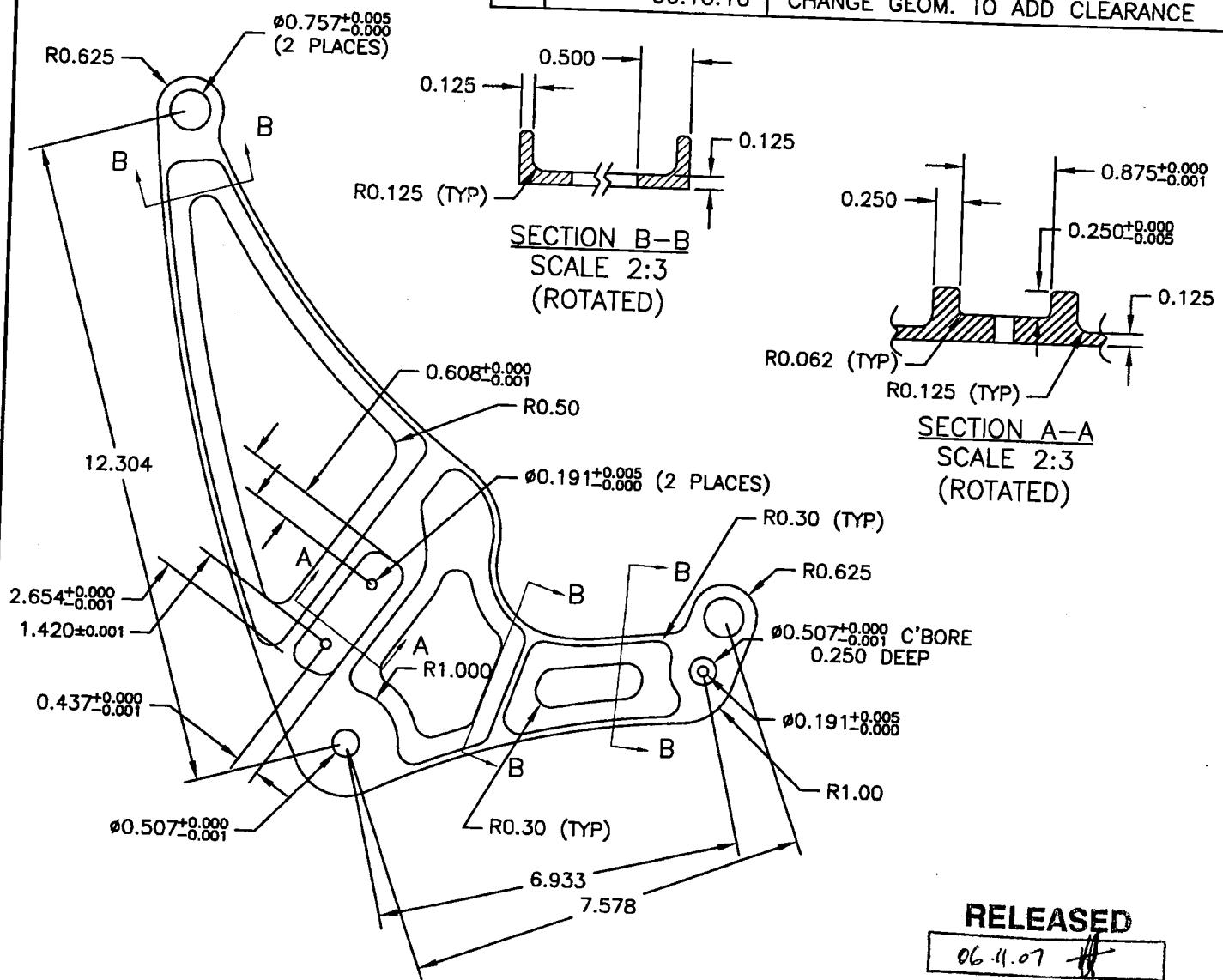
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804
DATE 06.10.16		REV. C SHEET 1 OF 2 SCALE 1:3
		TITLE STA 155 BRACKET
A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE



RELEASED

06.11.07 *[initials]*

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER

NO. *516104*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

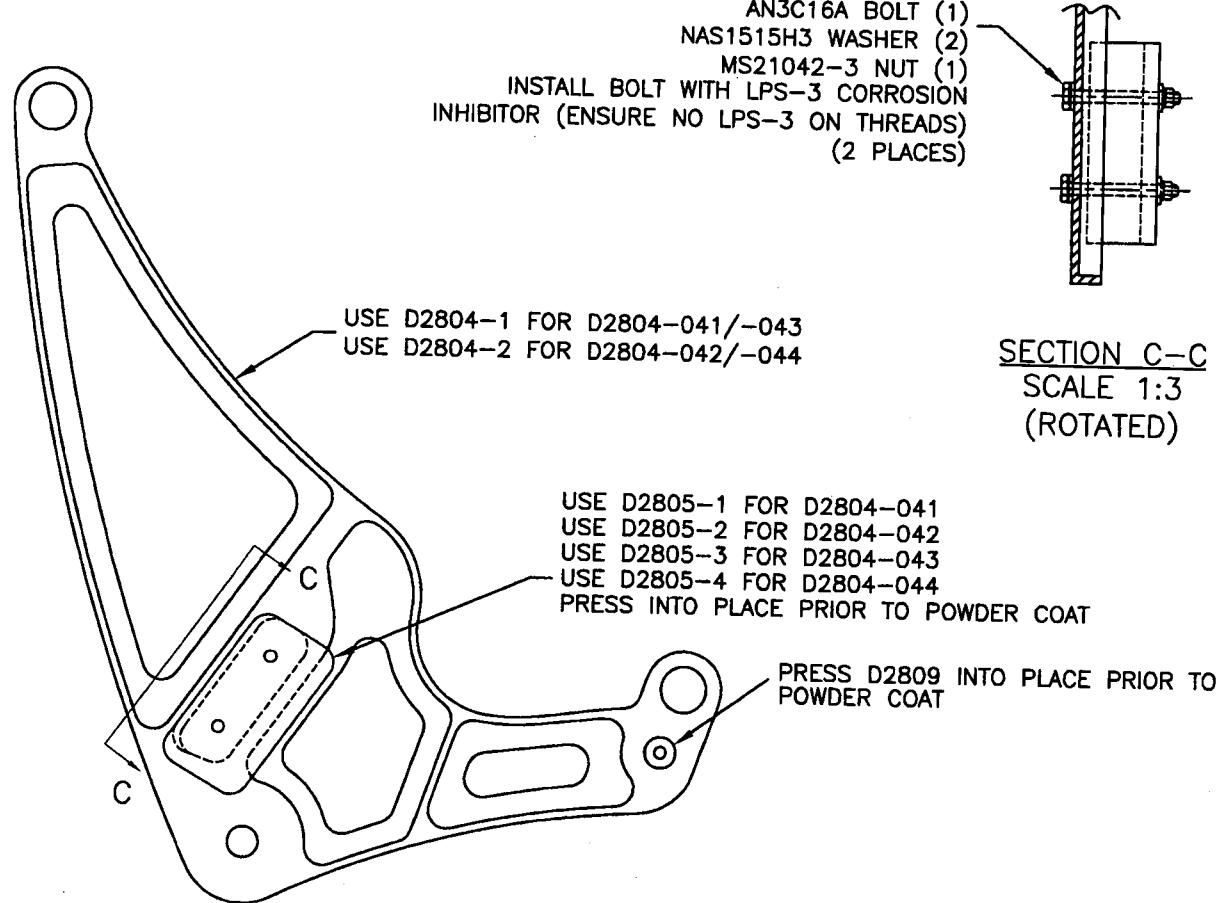
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



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06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN)  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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